

Work Order ID 69262

Thursday, May 05, 2011 2:51:28 PM

Page 1

Item ID: D2506

Accept

Revision ID:

Item Name: Label Plate

Start Date: 5/5/2011 Start Qty: 5.00

Required Date: 5/12/2011 Req'd Qty: 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2506

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2506
Deburr if necessary☐ Dwg Rev:

F

☐ Prog Rev:

F

☐ 2-

B11-5-6

(10)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-5-6

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

M

11

05

06

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2506

Accept



Setup Start



Revision ID:

Stop



Item Name: Label Plate

Start Date: 5/5/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo 1-Form as per dwg D2506	0.00 0.00				(10)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(40)			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00				(10)			

SB 11/05/09

J 11/05/09

SAD
11-05-09

W/O:		WORK ORDER CHANGES						
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Page 3

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Accept

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Start Date: 5/5/2011 Start Qty: 5.00

Required Date: 5/12/2011 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

5/5/11

MF
11-05-10

W/O:		WORK ORDER CHANGES						
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Picklist Print

Thursday, May 05, 2011 2:51:34 PM

Page 1

Work Order ID: 69262

Parent Item: D2506

Parent Item Name: Label Plate



Start Date: 5/5/2011

Required Date: 5/12/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B 01.06.08 ☐ Now laser cut ☐ EC ☐
IPP C 06.12.13 ecn 822 ec
IPP Rev:D 08-12-01 rev.F as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

128.2000

1.22

6.421053

12.5



304/316 .040 Sheet



12.5

Location

MAT020

116623

117550

Loc Qty

128.2

0.2

128

Loc Code

117550

10

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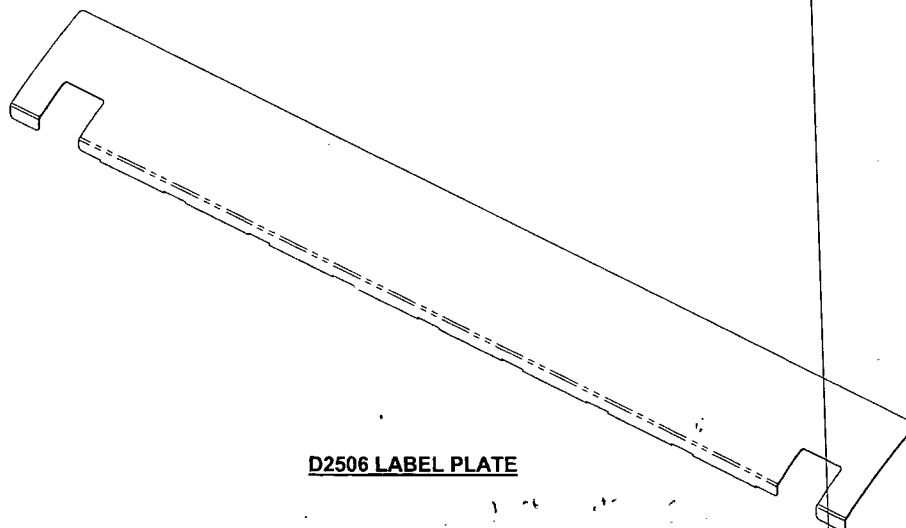
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D2506 LABEL PLATE

SHOP
RETURN
ENGINEERING
UNCONTROLLED
SUBJECT TO
WITHOUT NOTICE
WORK ORDER
NO. *69262*
11-05-5

RELEASE
08/11/18

- NOTES:**
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 *A*
REF. DART SPEC. M304S20GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.92 lbs

F	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT; UPDATED NOTE 1 (ZN A6-1); ADDED DETAIL A (ZN C8-2); 124" X 1" WAS 127" (ZN A4-2). REASONS: EASE MANUFACTURING WITH CORRECTION OF BEND AND ADDITION OF INTERMITTENT WELDING LOCATORS	MB	08.09.23
E	REMOVE 10" BEND; ADD NOTES; 127" WAS 126"	CB	06.11.20
D	32.63 WAS 32.25; 1.31 WAS 1.50	KE	99.10.04
C	RE-DESIGN OF LABEL PLATE	MM	96.09.04
B	RE-DESIGN OF LABEL PLATE	MM	96.06.18
A	NEW ISSUE	KH	95.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>JS</i>	D2506	SHEET 1 OF 2
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	LABEL PLATE	NTS
DATE	08.09.23	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

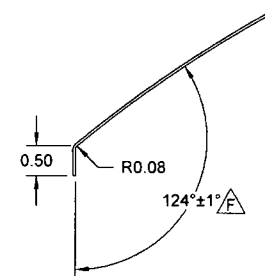
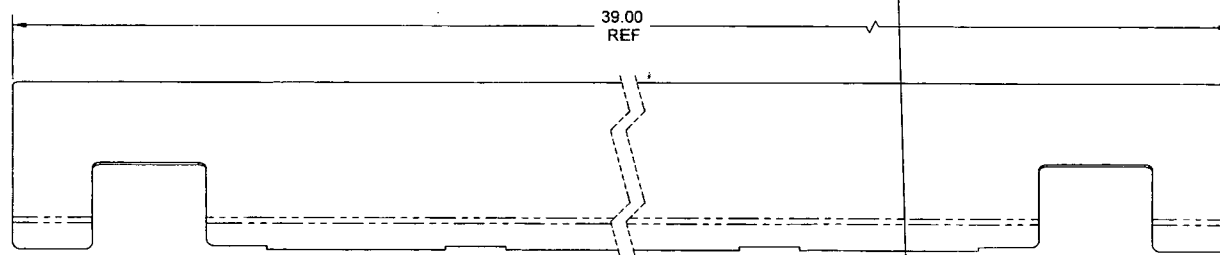
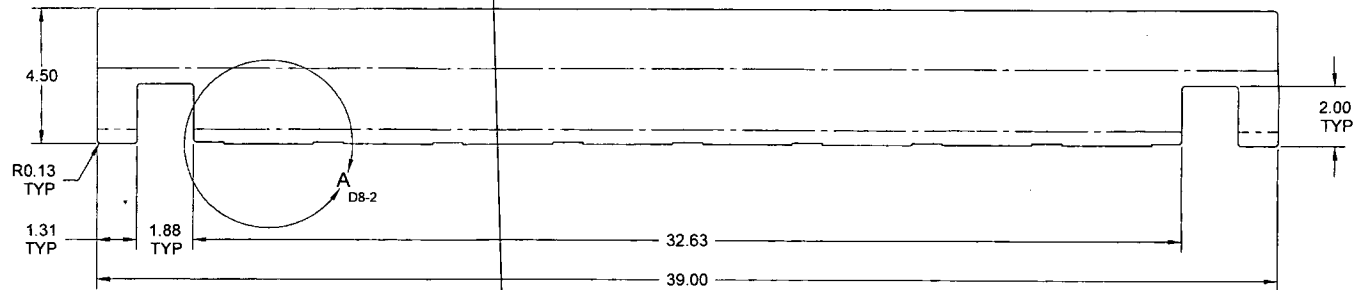
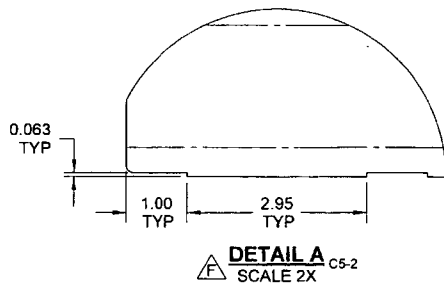
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RELEASED
08/07/14

DESIGN	BV	DART AEROSPACE LTD	
DRAWN	1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	215	DRAWING NO.	REV. F
MFG. APPR.	10	D2506	SHEET 2 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	10	LABEL PLATE	NTS
DATE	08.09.23	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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